

Work Order ID 104824

July 18/07

104824

Page 1

July-18-13 3:26:31 PM

Item ID: D4092-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Maintenance Step Assembly

Stop

NS2

Start Date: 7/18/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/19/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4092	B

100 Pick Kit 0.00

100

Packaging

Packaging

✓ 8/3/19

110 0.00

110

Small Fab

Small Fab Memo 0.00

Memo

Assemble as per Dwg

Torque screws up to 15-25 in- lbs

✓ 8/3/19

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

✓ 8/3/19

13-19

Work Order ID 104824

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July-18-13 3:26:31 PM

Item ID: D4092-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Maintenance Step Assembly

Stop

NS2

Start Date: 7/18/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/19/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Packaging

Memo

0.00

1X

SD
13-7-19

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

MLJ 13-07-22

MF
13-7-22

Picklist Print

July-18-13 3:26:30 PM

Page 1

Work Order ID: 104824

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 7/18/13

Required Date: 7/19/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 Maintenance Step		Manufactured	No			100	Each	17.0000	2	2		EJS 3/07/19	
				<u>Location</u>			<u>Loc Qty</u>						
				GA			1						
				77852			1						
				ST241A			1						
				74303			1						
				ST270A			15						
				102366			15						
D4093-1 Bracket		Manufactured	No			100	Each	1.0000	1	1		EJS 3/07/19	
				<u>Location</u>			<u>Loc Qty</u>						
				ST201			1						
				93754			1						
D4093-3 Bracket		Manufactured	No			100	Each	4.0000	1	1		EJS 3/07/19	
				<u>Location</u>			<u>Loc Qty</u>						
				ST201			4						
				93253			4						
D4093-5 Bracket		Manufactured	No			100	Each	18.0000	2	2		EJS 3/07/19	
				<u>Location</u>			<u>Loc Qty</u>						
				ST093			16						
				102355			6						
				102780			10						
				ST139			2						
				99613			2						

Picklist Print

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Page 2

Work Order ID: 104824

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

Start Date: 7/18/13

Required Date: 7/19/13

Start Qty: 1.00

Required Qty: 1.00

MS24694-S54

Purchased

No

100

Each

544.0000

2

2

SCREW

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST303	544	
-------	-----	--

125535	544	
--------	-----	--

MS24694-S55

Purchased

No

100

Each

175.0000

8

8

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST303	175	
-------	-----	--

124296	61	
--------	----	--

125535	114	
--------	-----	--

MS24694-S56

Purchased

No

100

Each

87.0000

2

2

SCREW

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST303	87	
-------	----	--

121340	10	
--------	----	--

125535	77	
--------	----	--

NAS1149D0332J

Purchased

No

100

Each

3,145.0000

12

12

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST293	83	
-------	----	--

125268	83	
--------	----	--

ST294	3062	
-------	------	--

122973	68	
--------	----	--

125044	284	
--------	-----	--

m125807	2710	
---------	------	--

Picklist Print

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Page 3

Work Order ID: 104824

Parent Item: D4092-041

Parent Item Name: Maintenance Step Assembly

MS21042L3

Purchased

No

100

Each

7,959.0000

12

Start Date: 7/18/13

Start Qty: 1.00

Required Date: 7/19/13

Required Qty: 1.00

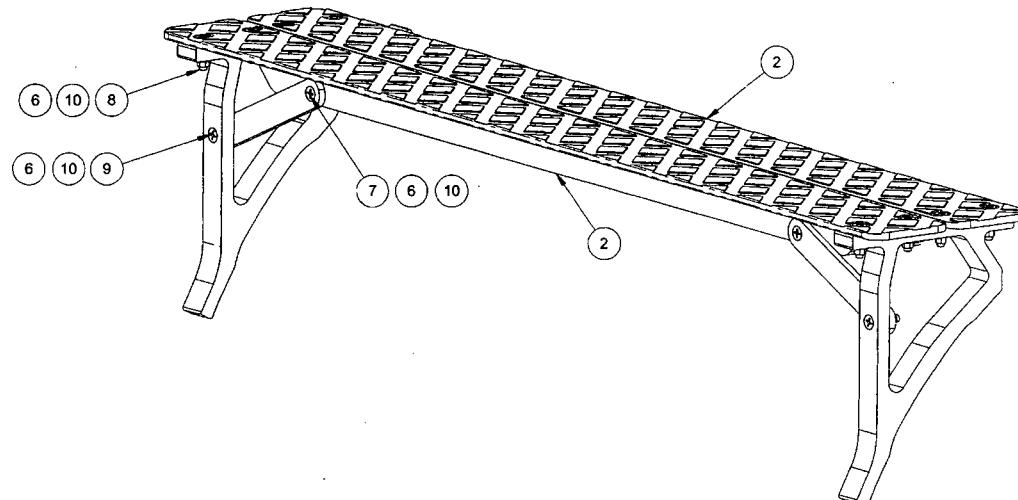
Nut

12

7/13/13

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	3	
	122141	3	
	GA	18	
	122452	18	
	ST314	1426	
	111668	1	
	117885	32	
	119017	55	
	119075	138	
	123265	43	
	M126036	1157	
	ST506	1512	
	123900	912	
	124291	600	
	ST510a	5000	
	M126275	1000	
	M126333	4000	

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



D4092-041 MAINTENANCE STEP ASSEMBLY

B

RELEASED
2011-09-22
MM

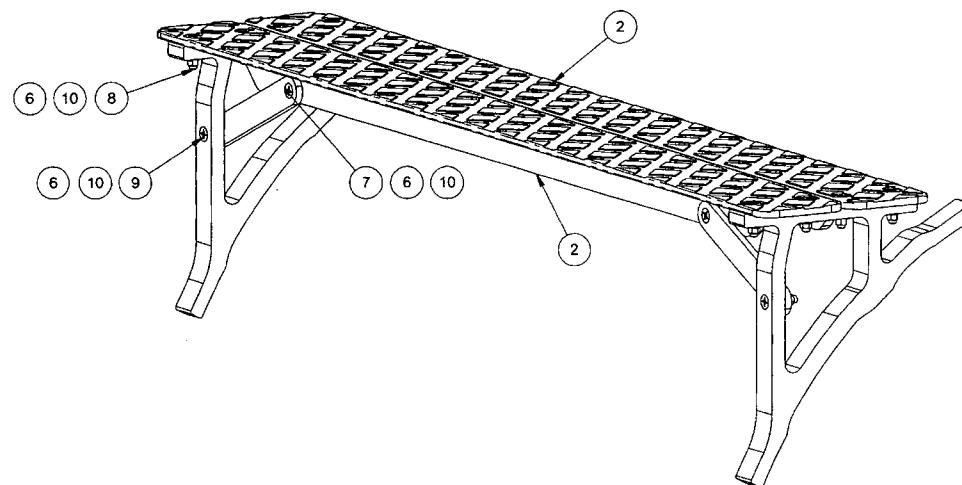
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A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION		
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DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 1 OF 6
APPROVED	142	TITLE	SCALE
DE APPR.	142	MAINTENANCE STEP ASS'Y	NTS
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8 7 6 5 4 3 2 1

MO 10/05/2011

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



D4092-042 MAINTENANCE STEP ASSEMBLY



RELEASED
2011-09-20
JW

8 7 6 5 4 3 2 1

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MFG. APPR.	9/1	REV. B
APPROVED	140	D4092
DE APPR.	#	SHEET 2 OF 6
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		MAINTENANCE STEP ASS'Y
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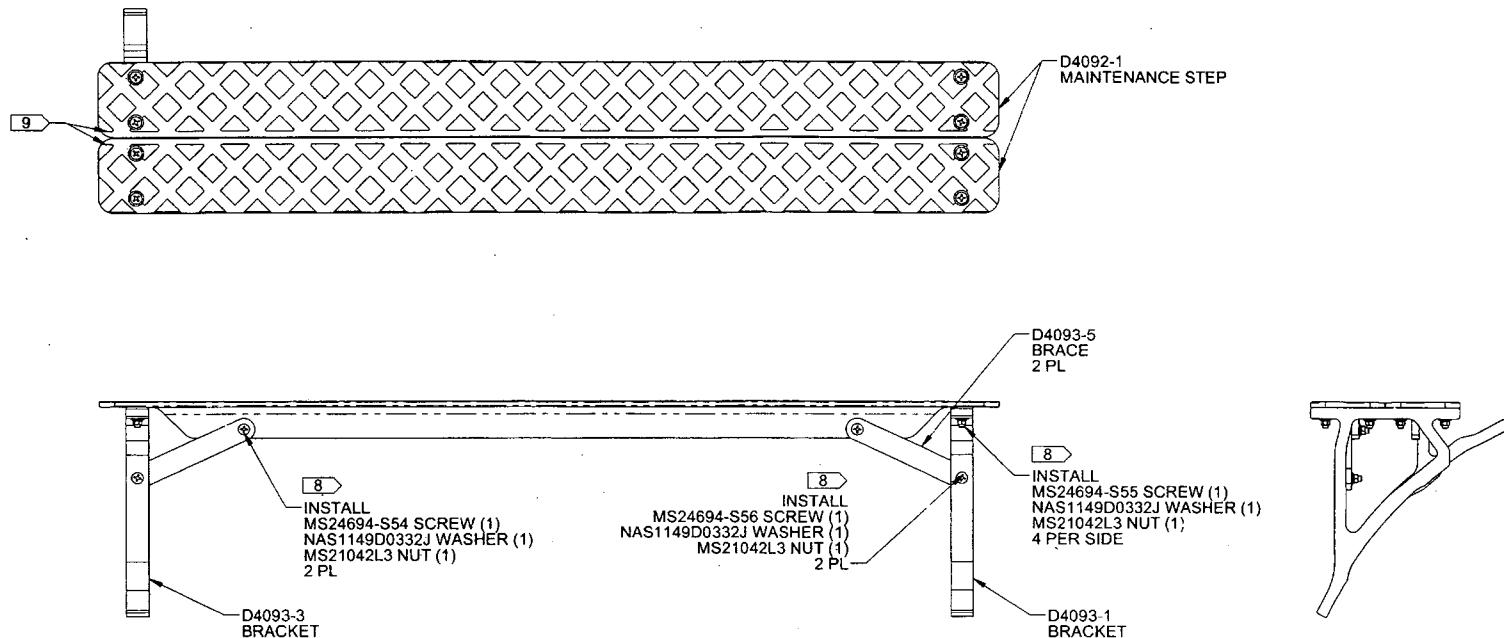
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B

B

A

A



D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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DE APPR.	140	TITLE	MAINTENANCE STEP ASS'Y
DATE	11.07.27	SCALE	NTS

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2011-09-22
140

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D

D

C

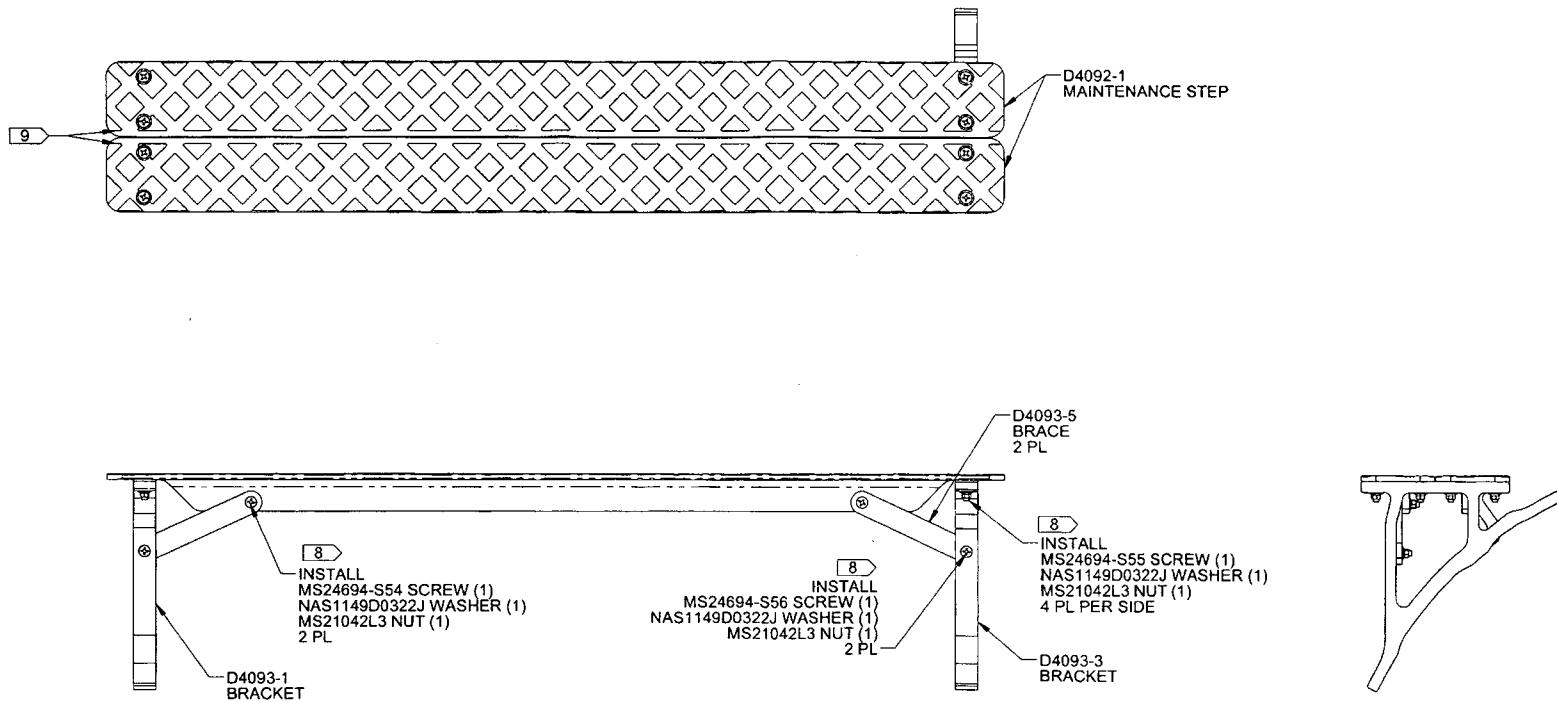
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B

B

A

A



D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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8 7 6 5 4 3 2 1

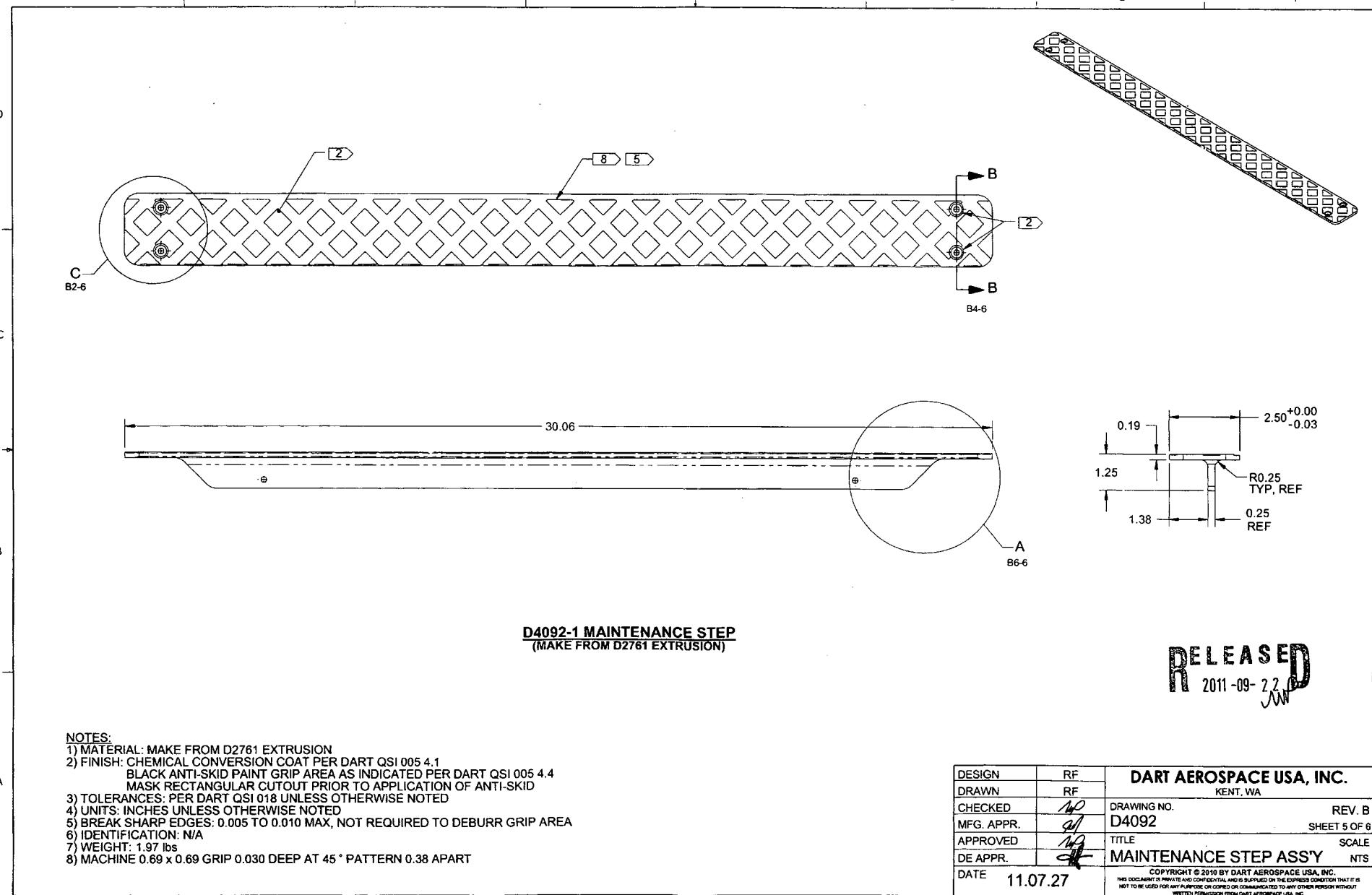
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APPROVED	<i>140</i>	D4092
DE APPR.	<i>140</i>	SHEET 4 OF 6
DATE	11.07.27	TITLE
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		NTS

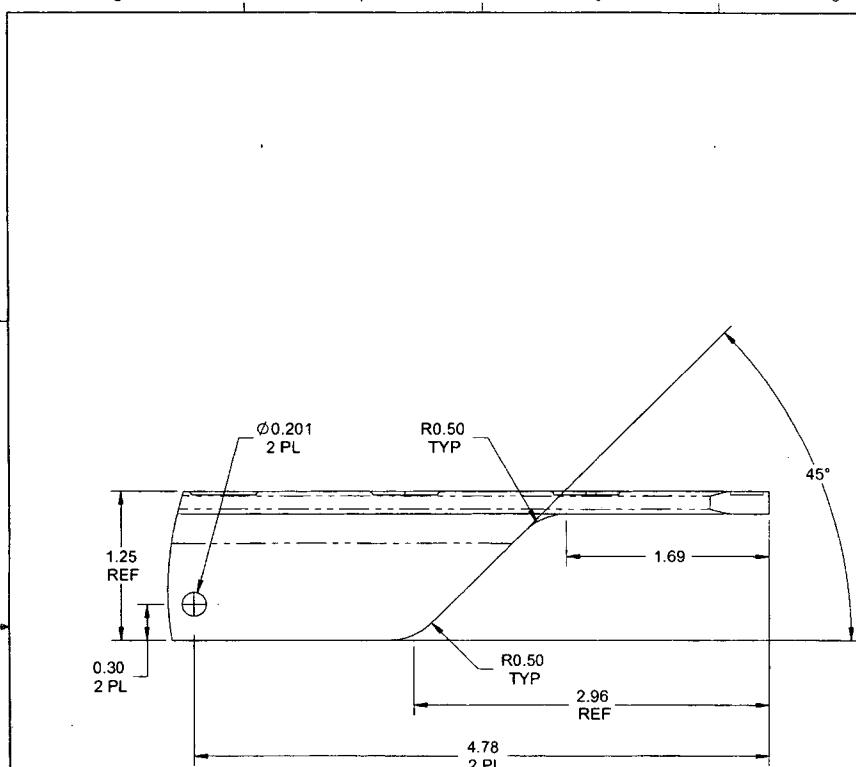
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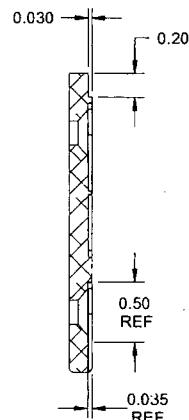
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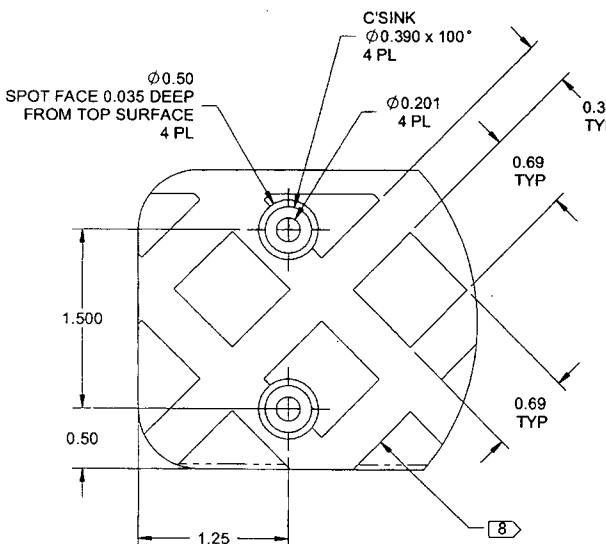




DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

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2011-09-22
MM

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DRAWN	RF	KENT, WA
CHECKED	140	DRAWING NO. D4092
MFG. APPR.	241	REV. B
APPROVED	141	SHEET 6 OF 6
DE APPR.	141	TITLE
DATE	11.07.27	SCALE NTS
		Maintenance Step Ass'y
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